

State of Illinois  
Illinois Department of Transportation

Addendum  
MANUAL FOR FABRICATION OF PRECAST PRESTRESSED CONCRETE PRODUCTS

Effective: March 25, 2019

Section 1.2.4, Note 1

Revise the 1<sup>st</sup> paragraph of Note 1 to read as follows:

“Sampling shall be at the point of placement. For each bed, a batch of concrete shall be sampled on the first batch and every 10 cu. yd. (8 cu. m) thereafter, except the minimum number of concrete batches sampled for a bed pour shall be two. Preference shall be given to sampling the first batch and the last full batch when only two batch samples are required. The frequency for strength samples may be increased from every 10 cu. yd. (8 cu. m) up to a maximum every 25 cu. yd. (20 cu. m) with approval of the Inspector. Additional sampling may be required as determined by the Inspector.”

Section 3.6.3

Replace the 3<sup>rd</sup> and 4<sup>th</sup> sentences of the numbered list (as previously amended effective 04/13/18) with the following:

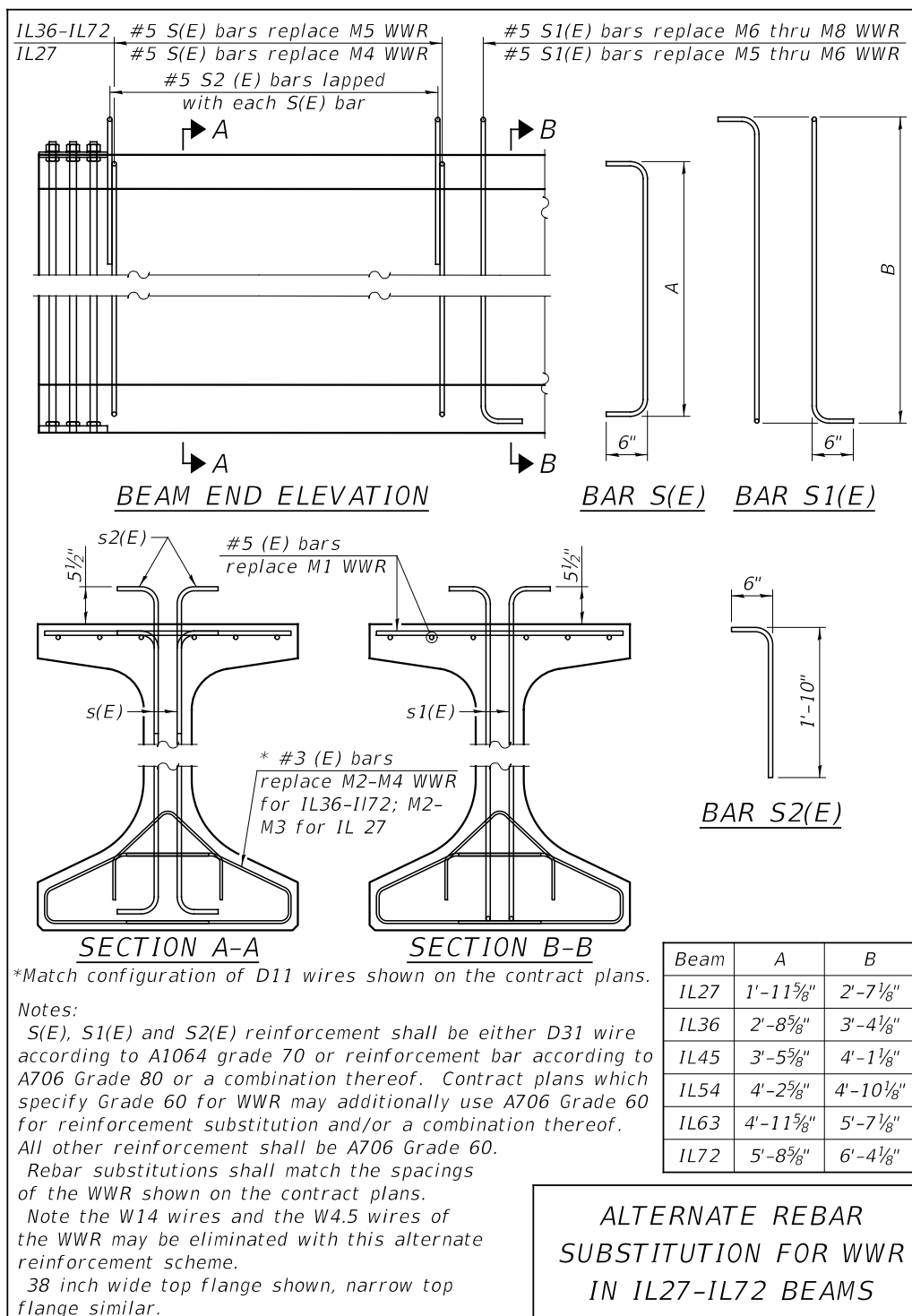
3. Precast prestressed concrete I-beams, Bulb T-beams, and IL-beams used for single-span bridges greater than 100 feet long – the 31<sup>st</sup> calendar day.
4. Precast prestressed concrete I-beams, Bulb T-beams, and IL-beams used for multi-span bridges – the 31<sup>st</sup> calendar day.

Add the following details to Appendix A as follows (see following pages for details):

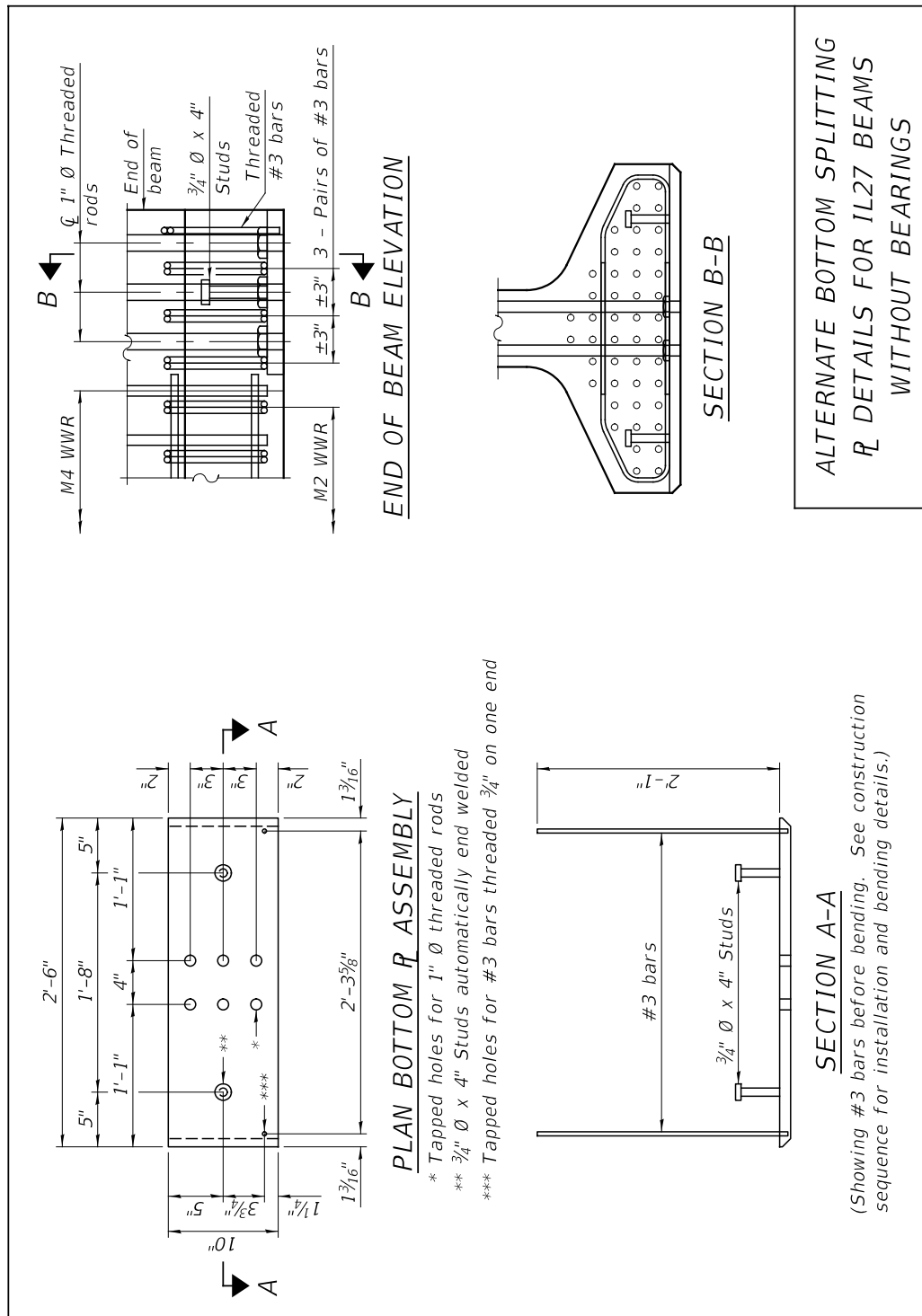
- Add new 1-page detail, “Alternate Rebar Substitution for WWR in IL27 – IL72 Beams”
- Add new 3-page detail for IL27 Beams,
  - “Alternate Bottom Splitting Plate Details for IL27 Beams Without Bearings”
  - “Alternate Bottom Splitting Plate Details for IL27 Beams With Bearings”
  - “Construction Sequence for Alternate Threaded #3 Bars”
- Add new 3-page detail for IL36 – IL72 Beams,
  - “Alternate Bottom Splitting Plate Details for IL36 – IL72 Beams Without Bearings”
  - “Alternate Bottom Splitting Plate Details for IL36 – IL72 Beams With Bearings”
  - “Construction Sequence for Alternate Threaded #3 Bars”

New 1-page detail,

**"Alternate Rebar Substitution for WWR in IL27 – IL72 Beams"**



New 3-page detail for IL27 Beams (page 1 of 3)

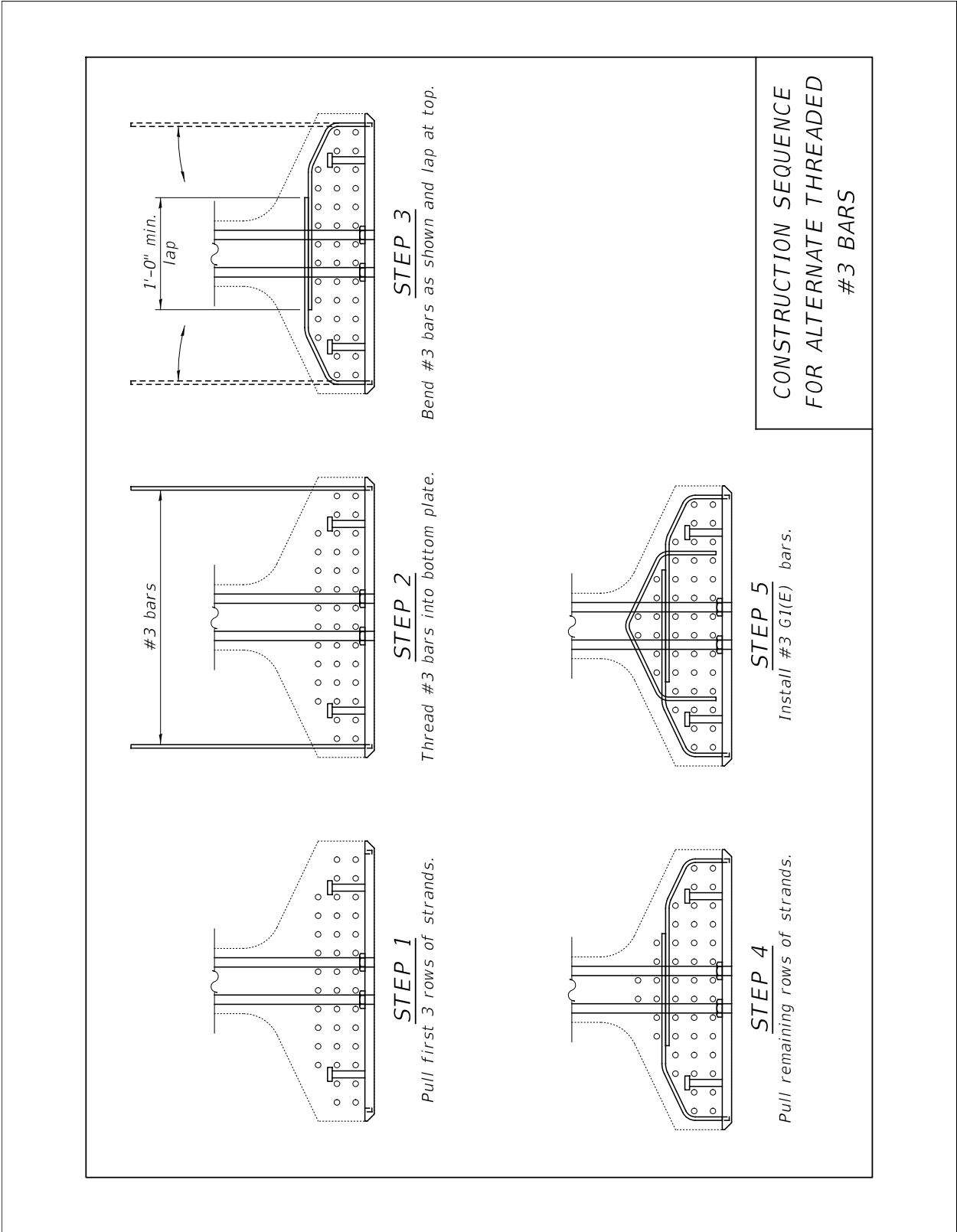
**"Alternate Bottom Splitting Plate Details for IL27 Beams Without Bearings"**

### “Alternate Bottom Splitting Plate Details for IL27 Beams With Bearings”

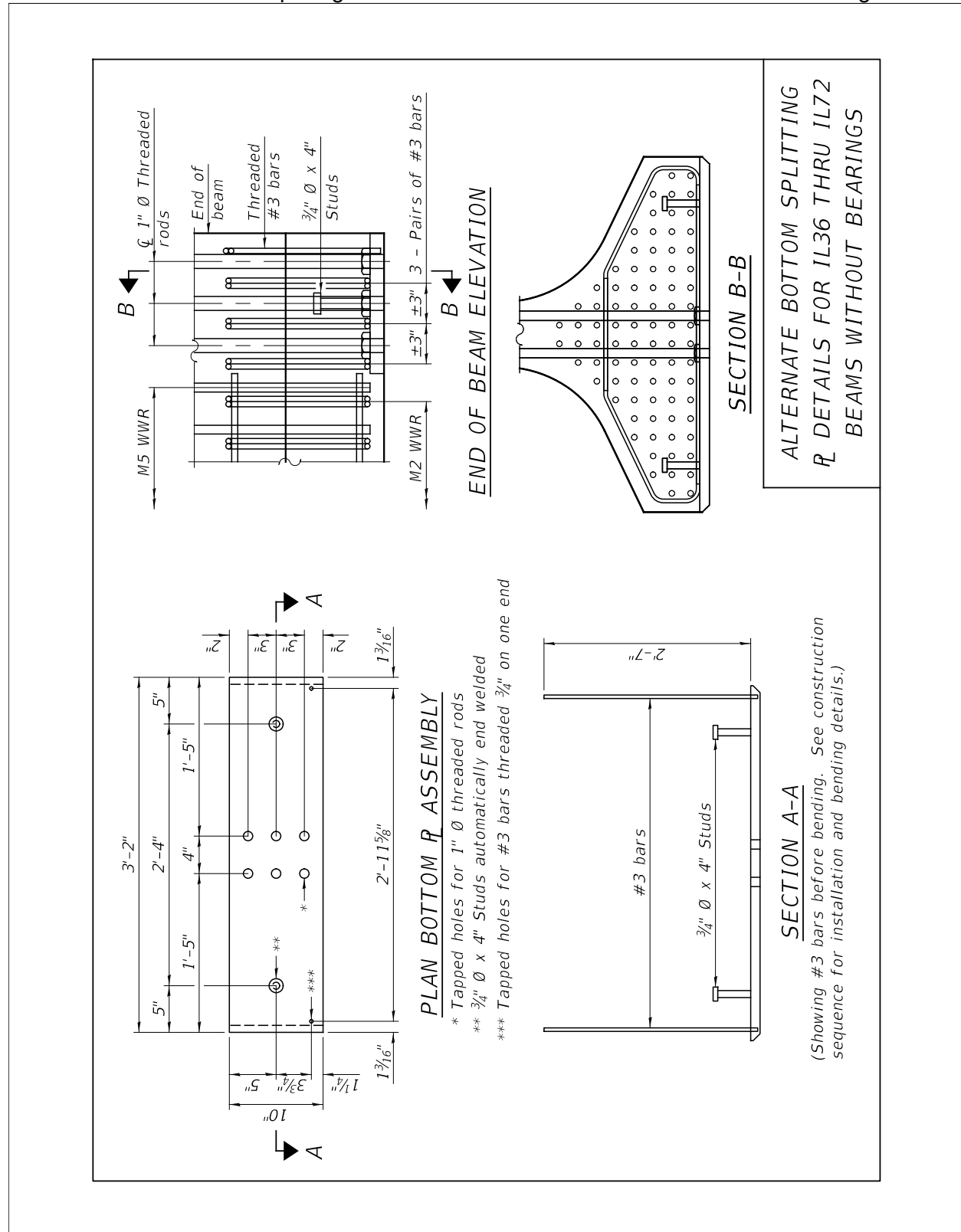


New 3-page detail for IL27 Beams (page 3 of 3)

“Construction Sequence for Alternate Threaded #3 Bars”



New 3-page detail for IL36 – IL72 Beams (page 1 of 3)

**“Alternate Bottom Splitting Plate Details for IL36 – IL72 Beams Without Bearings”**

### “Alternate Bottom Splitting Plate Details for IL36 – IL72 Beams With Bearings”



New 3-page detail for IL36 – IL72 Beams (page 3 of 3)

## “Construction Sequence for Alternate Threaded #3 Bars”

